

Work Order ID 165110

Tuesday, August 15, 2017 3:19:51 PM

165110

Page 1

Item ID: D4634-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Replacement Panel Assembly
Start Date: 8/21/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 8/25/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: AUG 16 2017 Tooling: Date: Run Start ***NR1***
QC: 9-89 Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								
100		0.00							
100									
Small Fab	Memo	0.00							SEP 08 2017
Small Fab	Pick Kit								DAS 6 9-89
110		0.00							
110									
Small Fab	Memo	1.26							DAS 07 9-89
Small Fab	Assemble as per Dwg D4634-141								12/09/22

1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # M138089

Expiry Date Sept 27/17

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

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125 *125* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02							
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.01							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							

SMB
17/9/22

WO# 165109

DAS
07
9-89

L

17/9/22

17/9/25

DAS
21
9-89

SEP 22 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Page 1

Work Order ID: 165110

165110

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09
Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23
DL IPP REV E Dwg update 14/01/09
DL IPP Rev F Dwg. update 14/02/03
DL IPP Rev G Dwg. Update 15/01/27
DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5021-1 *D5021-1* Foam, Center Panel, Fwd		Manufactured	No	w/o 165003		100	Each	0.0000	1	1			DAS 07 9-89 17/09/22
MS21059L08 *MS21059L 08* Nut		Purchased	No			100	Each	99.0000	2	2		SEP 09 2017	DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		99							
				m134943		1							
				m136554		98							
MS20426AD3-4 *MS20426AD3-4* RIVET		Purchased	No			100	Each	7,218.000	4	4		SEP 09 2017	DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		5644							
				m134294		1921							
				m136444		3723							
				ST312		1574							
				m131697		48							
				m134294		1526							

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Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-6

Purchased

No

100

Each

984.0000

2

2

MS20426AD4-6

Rivet

**

SEP 09 2017

Location

Loc Qty

Loc Code

CCK004

861

M137851

861

GA

37

M134502

25

M137851

12

ST311

86

M136537

86

D4634-1

Manufactured

No

100

Each

0.0000

1

1

D4634-1

Fwd, Center Ceiling Panel

D4636-5

Manufactured

No

100

Each

37.0000

1

1

D4636-5

Bracket

**

**

SEP 09 2017

Location

Loc Qty

Loc Code

ST115

37

154916

17

164519

20

D4647-5

Manufactured

No

100

Each

3.0000

1

1

D4647-5

Doubler

**

SEP 09 2017

Location

Loc Qty

Loc Code

MF004

3

129252

3

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D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

D4664-5

Manufactured No

100 Each

9.0000

6 6

D4664-5

Spacer

**

DAS
6
9-89

SEP 11 9 2017

Location

Loc Qty

Loc Code

MF004

9

155824

9

D4712-1

Manufactured No

100 Each

2.0000

1 1

D4712-1

Bracket

**

DAS
6
9-89

SEP 09 2017

Location

Loc Qty

Loc Code

MF004

2

163711

2

D4732-15

Manufactured No

100 Each

3.0000

1 1

D4732-15

Label

**

DAS
6
9-89

SEP 09 2017

Location

Loc Qty

Loc Code

MF005

3

157453

3

D4732-19

Manufactured No

100 Each

3.0000

1 1

D4732-19

Label

**

DAS
6
9-89

SEP 09 2017

Location

Loc Qty

Loc Code

MF005

3

123209

3

MPNY-750S-9-C

Purchased No

100 Each

603.0000

7 7

MPNY-750S-9-C

Mounting Pad

**

DAS
6
9-89

SEP 09 2017

Location

Loc Qty

Loc Code

ST569

603

M130423

603

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Page 3

DQA: _____ Date: _____

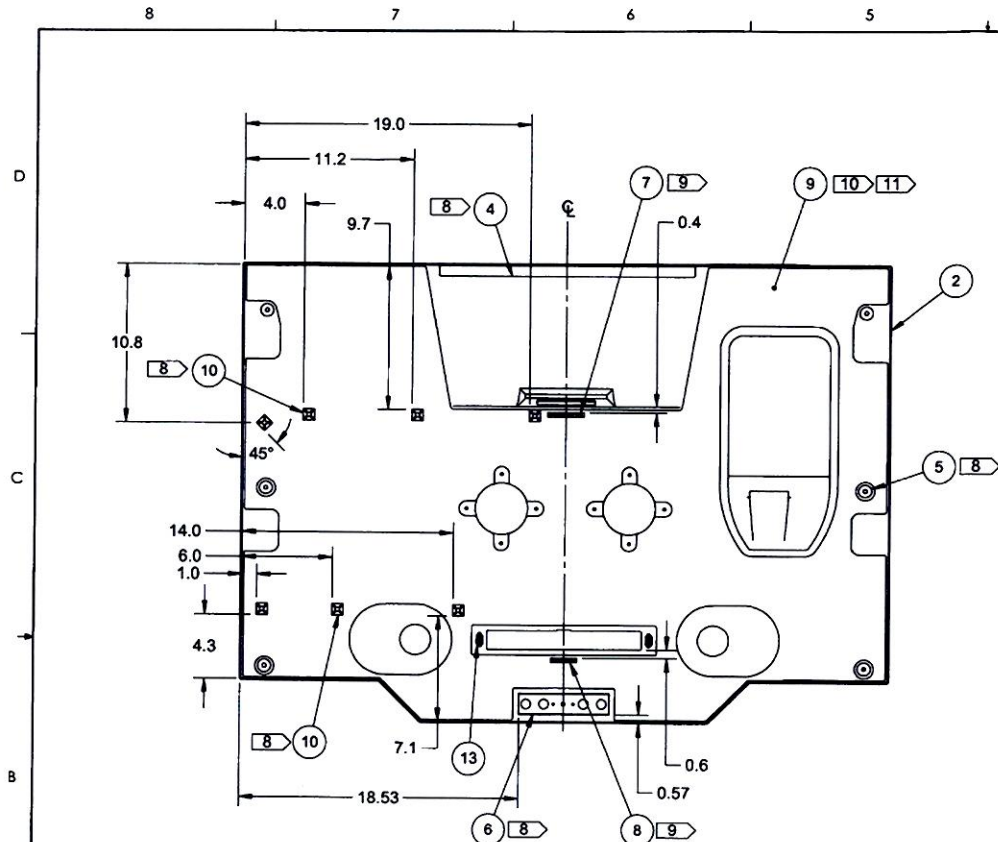
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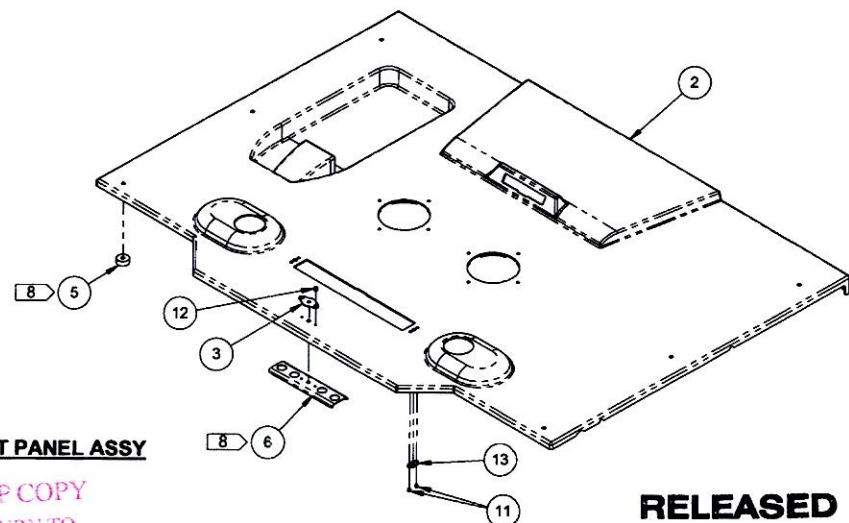


D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4664-5, D4712-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-1 FOAM ON D4634-1

ITEM	QTY -141	P/N	DESCRIPTION
1	X	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-5	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-15	LABEL
8	1	D4732-19	LABEL
9	1	D5021-1	FOAM, CENTER PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET, SOLID, CSK
12	2	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE



RELEASED
2015 JAN 26 *qp*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165110415
170816

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. G
CHECKED	AK	D4634	SHEET 7 OF 17
MFG. APPR.	DL	TITLE	SCALE
APPROVED	HS	CENTER CEILING PANELS	NTS
DE APPR.	DS	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	14.11.28		